

Work Order ID 126181

Thursday, October 30, 2014 9:56:21 AM

126181

Page 1

Item ID: D3319-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Forward Wearplate

Start Date: 10/30/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: *MCS*Date: *10-30-14* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3319 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
NOV 03 2014

Work Order ID 126181

Thursday, October 30, 2014 9:56:21 AM

126181

Page 2

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N900040100

Setup Start ***NS1***

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Stop ***NS2***

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Required Date: 10/30/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

140

Brake NC

Brake NC

NC BRAKE

Memo

0.00

1- Form using DT8326 & DT8261 as per Dwg D3319Rev: C
2- Form flat on press using DT8776 block

DAS
30
9-89

13

14/10/05

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

13

DAS
38
9-89
NOV 03 2014

160

160

Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch ~~128603~~ 0.00
Large Fab

Memo

0.00

1- Layout weld location as per Dwg D3319 using jig D3319-IT3
2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: ____
Qty Part Number Description Batch
A/R N/A 228/7560 Hardcoat Rod ____

13

14-11-11
JBL

Work Order ID 126181

Thursday, October 30, 2014 9:56:21 AM

126181

Page 3

Item ID: D3319-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Forward Wearplate

Start Date: 10/30/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

13 14-12

DAS
50
9-89

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

13

DAS
30
9-89

NOV 12 2014

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:40
320°
9:10

13 14-11-14

DAS
34
9-89

Work Order ID 126181

126181

Page 4

Thursday, October 30, 2014 9:56:21 AM

Item ID: D3319-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Forward Wearplate

Start Date: 10/30/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

38
9-89

NOV 17 2014

210

Identify as per dwg & Stock Location: st 601

0.00

210

Packaging

Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock

Location: st 601

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

13 14/11/18

14/11/18

mf 14-11-18

Picklist Print

Thursday, October 30, 2014 9:56:26 AM

Page 1

Work Order ID: 126181

126181

Parent Item: D3319-1

D3319-1

Parent Item Name: Forward Wearplate

Start Date: 10/30/2014

Required Date: 10/30/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	183.2709	0.628	8			

M1010S18GA

1010/1025 SHEET .048

DL 14/11/01

Location

Loc Qty

Loc Code

MAT

100

m130454

100

MAT019

83.2709

116268

0.970948

117806

18

124428

31

m129674

33.3

10.5101

94236
3.497
1.4895

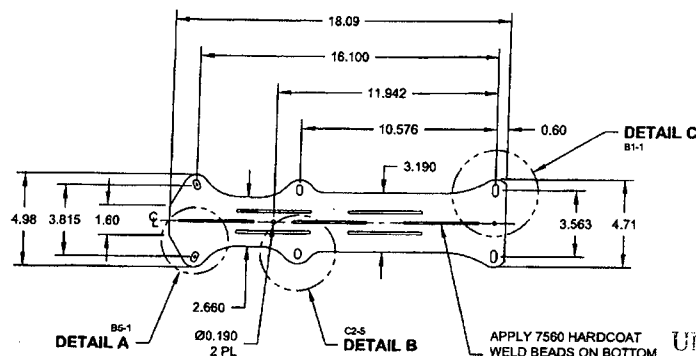
DART AEROSPACE LTD		Work Order:	126181
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.98	+/-0.030	4.98	/			
1.600	+/-0.010	1.600	/			
2.660	+/-0.010	2.667	/			
3.190	+/-0.010	3.197	/			
3.563	+/-0.010	3.563	/			
4.71	+/-0.030	4.71	/			
0.60	+/-0.030	.60	/			
10.576	+/-0.010	10.576	/			
11.942	+/-0.010	11.942	/			
18.09	+/-0.030	18.09	/			
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	.317 x .544	/			
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	.314 x .670	/			
Ø0.190	+0.005/-0.001	.187	/			
3.815	+/-0.010	3.815	/			
16.100	+/-0.010	16.100	/			

Measured by:	EL/PL	Audited by:	DAS 38	Preliminary Approval:	
Date:	14-11-01	Date:	9-89 NOV 03 2014	Date:	

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



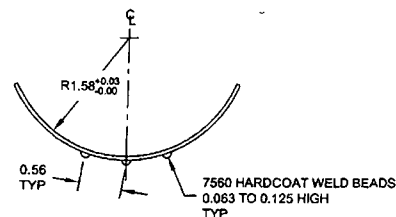
D3319-1F FLAT PATTERN

APPLY 7560 HARDCOAT WELD BEADS ON BOTTOM SURFACE AFTER FORMING SEE SECTION D-D A5-5

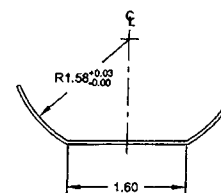
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

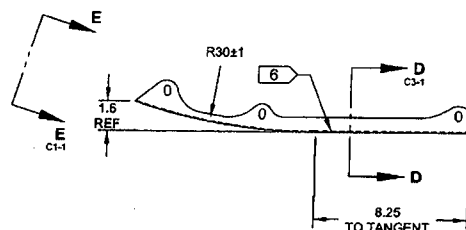
NO. 126181 M530
14-10-80



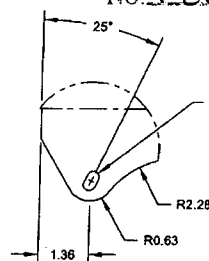
SECTION D-D B5-1
SCALE 4X



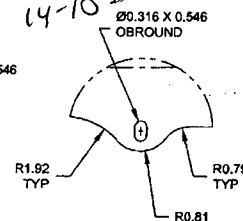
SECTION E-E B5-1
SCALE 4X



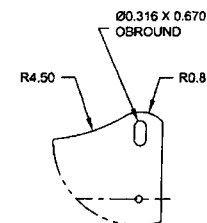
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A C5-1
SCALE 4X



DETAIL B C5-1
SCALE 4X



DETAIL C C5-1
SCALE 4X

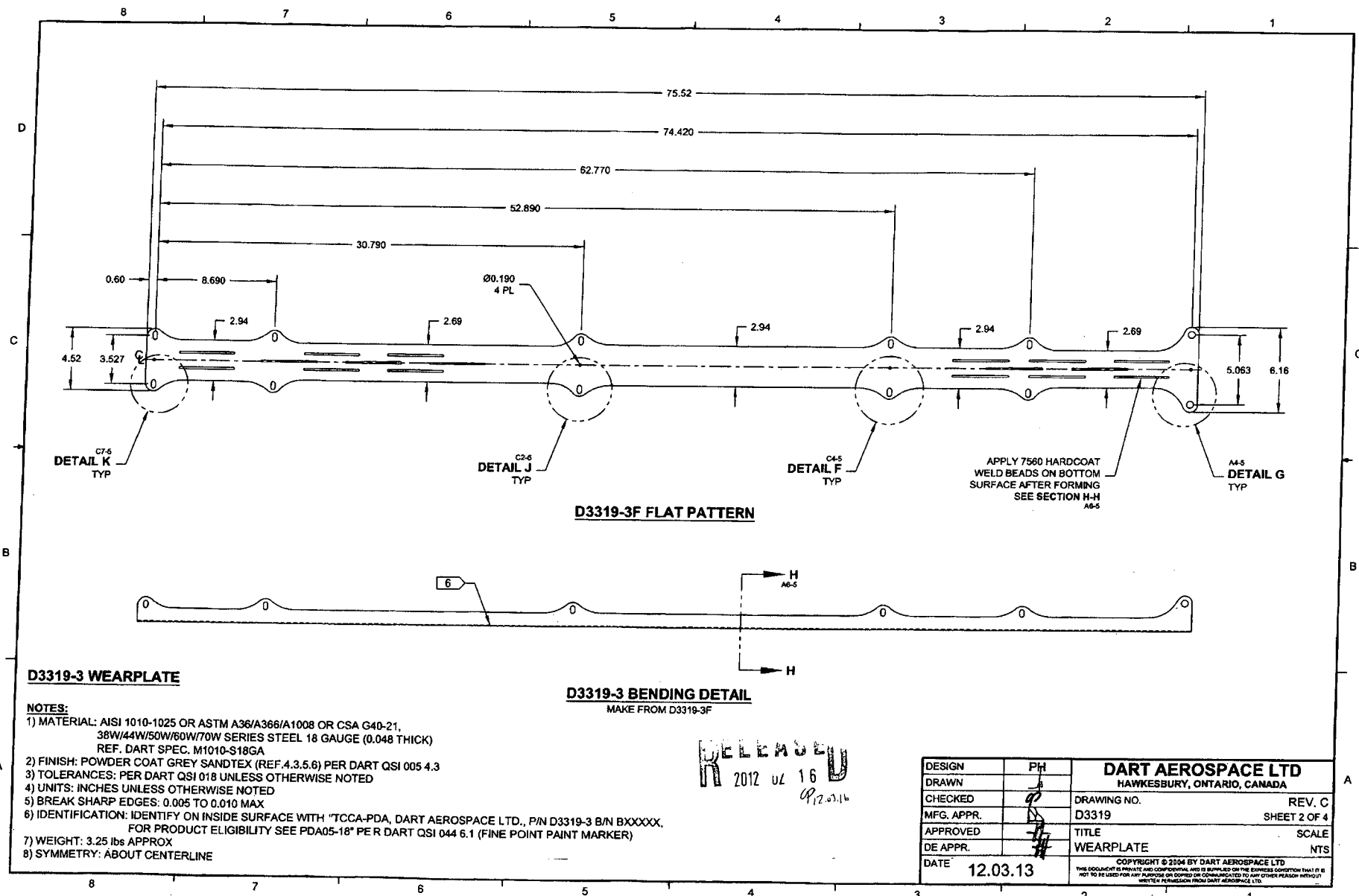
D3319-1 WEARPLATE

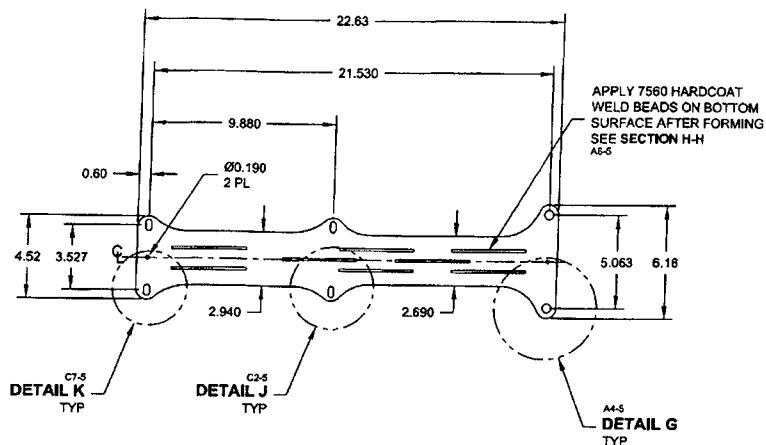
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

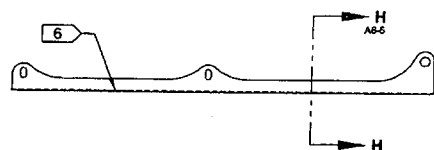
RELEASED
2012-03-16
PER ECN 12-546 12-3-16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/-5/-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5/-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3319 SHEET 1 OF 4 TITLE WEARPLATE SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	12.03.13		

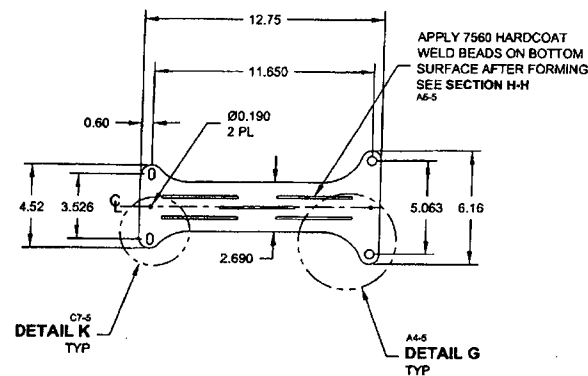




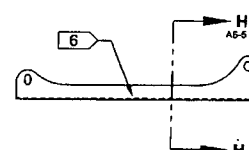
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

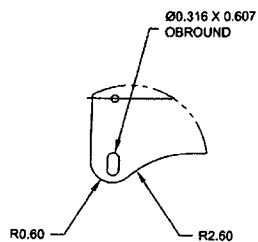
D3319-5/-7 WEARPLATE

NOTES:

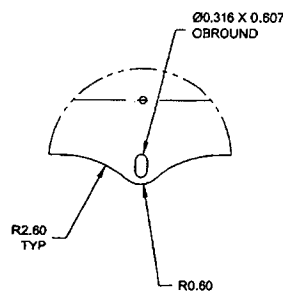
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16
912.6336

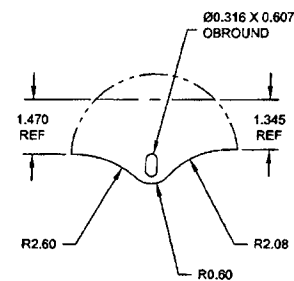
DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NT
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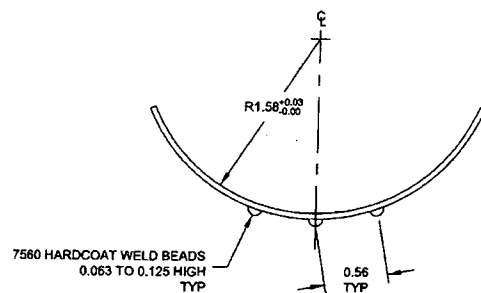
DETAIL K
SCALE 2X
B8-2
C4-3
C8-3



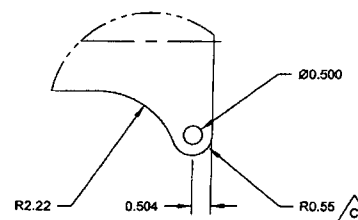
DETAIL F
SCALE 2X
B8-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C6-3
C

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2012-02-16
12.03.13

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3319	REV. C
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE WEARPLATE	SCALE NTS
DE APPR.			
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